



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBD29932
Job Sheet 195991



Part No: RBD29932

Job Qty: 1 pcs

Part Name: Main Rotor Puller "D" Model (3 Jaw) Al



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/4/19

Job Tracking No:

Due Date: 8/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *over 16098*

Note: DWG RBD29932 REV A IPP Rev. A 19.04.02 New issue DP Verify DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S200754



Part: RBD29932

Job No: 195991

Serial No/Batch: S200754

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 07/26/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	8/1/19		0.00	0.50	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	8/1/19		0.00	0.00	QC 5 - 10		DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	8/1/19		0.00	0.00	Packaging 3 - 1 - B4B		JUL 26 2019 DAS 75 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	1 pcs	8/1/19		0.00	0.00	QC 21 - FG - 21		JUL 26 2019 DAS 70 9-89
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op 100 - Assemble as per DWG. See note 8,9,10 and 11.

Descriptions: 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

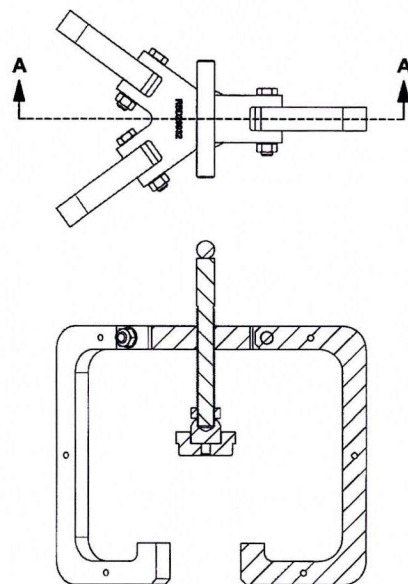
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN315-8R	Hex Nut	3 Ea (3 ea)	100-Small Fab - 1	5143734
AN8-24A	BOLT	3 Ea (3 ea)	100-Small Fab - 1	5124555
NAS1149F0832P	Washer	6 Ea (6 ea)	100-Small Fab - 1	5076018
RBD29932-1	Puller Nut	1 pcs (1 ea)	100-Small Fab - 1	5188069
RBD29932-2	Puller	3 pcs (3 ea)	100-Small Fab - 1	5196513
RBD29932-3	Thrust Pad	1 pcs (1 ea)	100-Small Fab - 1	518637
RBD29932-4	Puller Screw	1 pcs (1 ea)	100-Small Fab - 1	5197064
TP-750	Black Oxide Steel Toggle Pad, Type TP, 3/4"-10 X 1-1/4" OD.	1 Ea (1 ea)	100-Small Fab - 1	5192278

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	AN315-8R	3	75	0
	AN8-24A	3	10	0
	NAS1149F0832P	6	221	0
	RBD29932-1	1	0	0
	RBD29932-2	3	0	0
	RBD29932-3	1	4	0
	RBD29932-4	1	0	0
	TP-750	1	0	0
Part Specifications				
Specifications could not be found.				

Plex 6/4/19 9:01 AM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-1	1	RBD29932-1	PULLER NUT
-2	3	RBD23392-2	PULLER
-3	1	RBD29932-3	THRUST PAD
-4	1	RBD29932-4	PULLER SCREW
7	1	Monroe#TP-750 OR EQUIV.	BLACK OXIDE STEEL TOGGLE PAD TYPE TP 3/4"-10 X 1-1/4" OD.
8	3	AN8-24A	BOLT
9	3	AN315-8R	NUT
10	6	NAS1149F0832P	WASHER



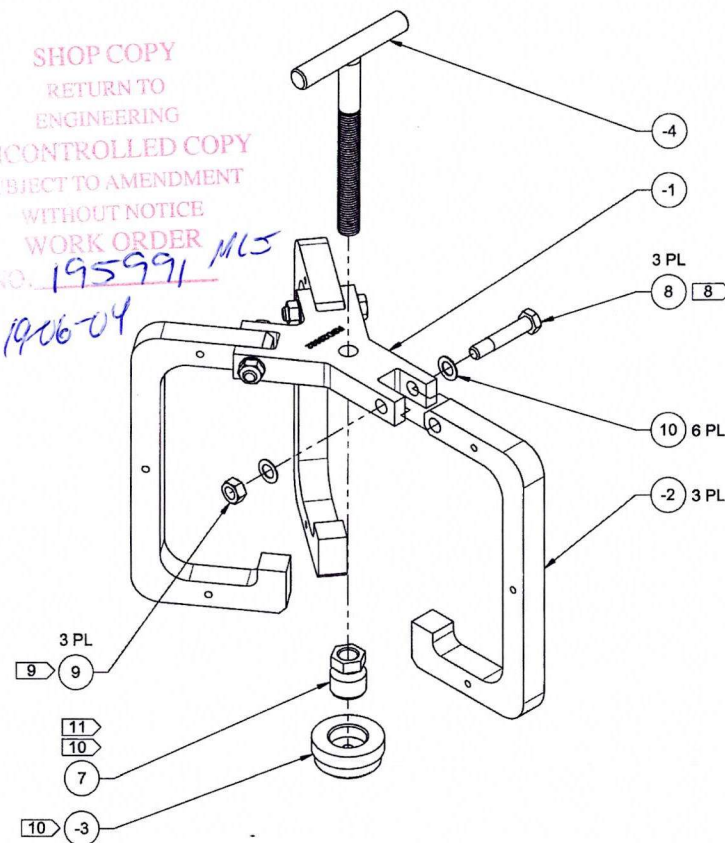
SECTION A-A

RBD29932 MAIN ROTOR PULLER "D" MODEL (3 JAWS) AI

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 8 THEN ASSEMBLE WITH ITEM 9, AND REMOVE EXCESS
- 9) TORQUE ITEM 9 TO 40-58 FT-LBS (480-690 IN-LBS)
- 10) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEM 7 AND ITEM -3, AND REMOVE EXCESS
- 11) INSTALL ITEMS 7 HAND TIGHT
- 12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195991 M15
1906-04



A	NEW ISSUE	19-643	MBB
REV.	DESCRIPTION	ECN #	BY
DESIGN	MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MBB	TOOL PART # RBD29932	
CHECKED	KPT	REV. A	
MFG. APPR.	DP	SHEET 1 OF 7	
APPROVED	VLP	TITLE MAIN ROTOR PULLER "D" MODEL (3 JAWS) AI	
DATE	4/2/2019	SCALE 1:1	
COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					